



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM652V3002102-7
Job Sheet 195656



Part No: RBEM652V3002102-7

Job Qty: 1 pcs

Part Name: Exchange Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/29/19

Job Tracking No:

Due Date: 6/26/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBEM652V3002102 Rev A IPP Rev. A 19.05.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	6/26/19	6/26/19	0.00	0.00	Purchasing - 1		JUN 26 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs	6/26/19	6/26/19	0.00	0.00	Packaging 2 - 1 - B4B		JUN 26 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194240



Part: RBEM652V3002102-7

Job No: 195656

Serial No/Batch: S194240

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 06/26/19

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				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6	1 pcs	6/26/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
130	Packaging 3-1 - Stock - B4B	1 pcs	6/26/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - SA	1 pcs	6/26/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

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MLL

GATBD

Part Op 100 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O 43577 -Manufacture RBEM652V3002102-7 as
 Descriptions: per DWG. -Certificate of Conformity is required
 110 - Certificate of Conformity is required
 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM652V3002102-7P	Exchange Assembly	1 (1 ea)	100-Purchasing	S194239

Job Allocations

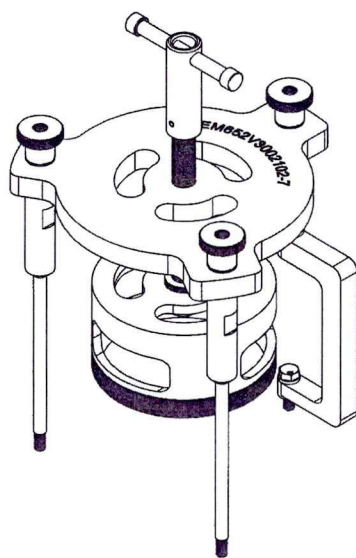
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBEM652V3002102-7P	1	0	0

Part Specifications

Specifications could not be found.

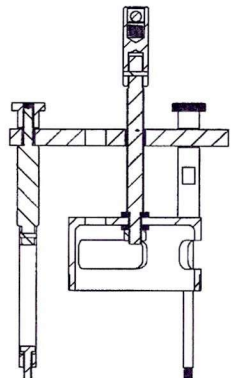
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ITEM #	QTY	PART #	PART TITLE
-8	1	RBEM652V3002102-8	GUIDE
-9	2	RBEM652V3002102-9	STUD
-10	1	RBEM652V3002102-10	BAR HANDLE NUT
-11	1	RBEM652V3002102-11	SCREW
-12	1	RBEM652V3002102-12	PLATE ASSY
-14	1	RBEM652V3002102-14	FOOT ASSY
21	1	McMaster#98380A473 OR EQUIV.	416 SS DOWEL PIN 1/8" DIA. X 3/4" LG.
22	1	McMaster#94895A815 OR EQUIV	ZINC YELLOW PLATED GRADE 8 STEEL HEX NUT 3/8"-24
23	3	McMaster#60765K343 OR EQUIV	STEEL ROUND KNOB M8 X 1.25mm THROUGH X 25mm HEAD DIA.
24	3	McMaster#95229A480 OR EQUIV	CAD PLATE STEEL WASHER 5/8" OD X 0.39" ID X 0.029-0.035 THK.
25	4	TRA-613	STEEL THRUST WASHER 0.377" ID. X 13/16" OD. X 0.032" THK.
26	2	NTA-613	STEEL NEEDLE ROLLER THRUST BEARING 0.377" ID. X 13/16" OD. X 5/64" THK.

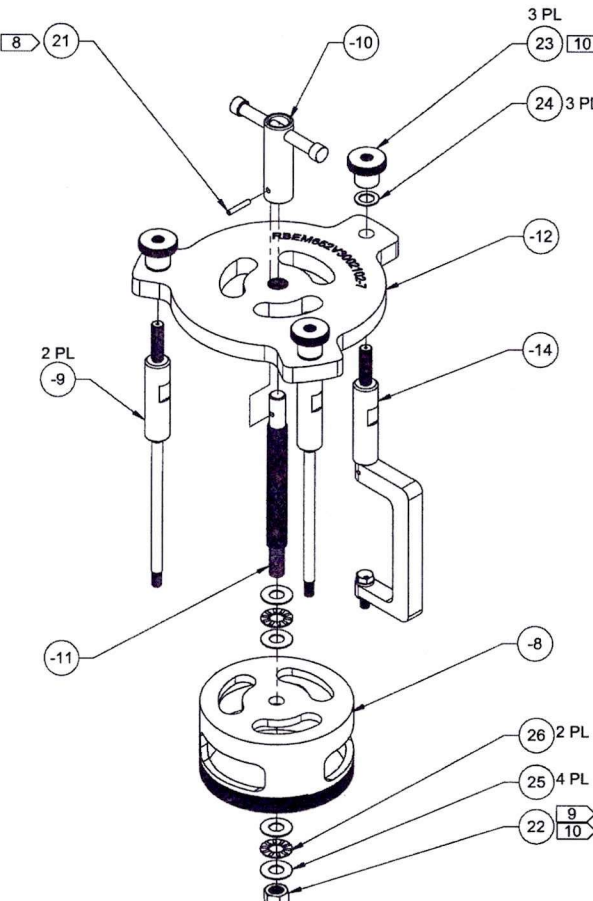
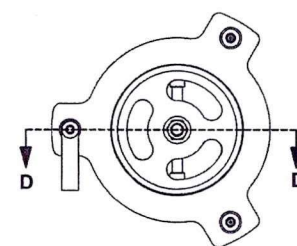


RBEM652V3002102-7 EXCHANGE ASSEMBLY

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SECTION D-D



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 21 WITH ITEM -10 AND ITEM -11 AND REMOVE EXCESS
 - 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 22 THEN ASSEMBLE WITH ITEM -11, AND REMOVE EXCESS
 - 10) ASSEMBLE ITEM 22 AND ITEM 23 HAND TIGHT
 - 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 8 OF 17
APPROVED	VM	TITLE	SCALE
DATE	2019-05-24	TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043577



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB043577

PO Date: 5/29/19

Due Date: 6/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	195655	RBEM652V3002102-5P			Guide Assembly REV A	Firmed	-	6/26/19	1 Ea	0 Ea	1 Ea	\$676.42/Ea	\$676.42
						1 x	JUN 26 2019						
2	195656	RBEM652V3002102-7P			Exchange Assembly REV A	Firmed	-	6/26/19	1 Ea	0 Ea	1 Ea	\$3,468.58/Ea	\$3,468.58
						1 x	JUN 26 2019						
Grand Total:												\$4,145.00	

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Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

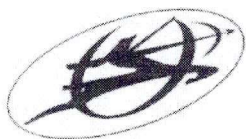
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Handwritten signature and date: 5/29/19

Plex 5/29/19 1:15 PM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 600

Date: 6/25/2019
PO Ref: HB043577 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
1 ✓	GUIDE ASSEMBLY	✓ RBEM652V3002102-5 REV A
1 ✓	EXCHANGE ASSEMBLY	✓ RBEM652V3002102-7 REV A

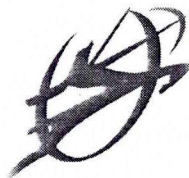
RECEIVED

JUN 26 2019

DART AEROSPACE LTD.

Received by: _____
Packaged by: J.M.L.
Checked by: ADP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043577 ✓

Dated: 6/25/2019

Our Order / Job No: HB043577-2AWT

Order Qty: 1 ✓

Part Name: EXCHANGE ASSEMBLY

Part Number RBEM652V3002102-7 ✓

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Lot Size: N/A

Ship Date: 6/25/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBEM652V3002102-7

Rev: A

Material Size and Type: -8, -11/4140 STEEL Q&T; -9, -15, -16/ O1 STEEL; -13/6061-T6 ALUM.

Material Specifications: STEEL: ASTM A108; O1 STEEL: ASTM A681; ALUM.: ASTM B209

Heat Treatment: (28-32 HRC); -9, -15, -16/ 52.30 HRC – 52.0 HRC

Plating/Finish: RED ANODIZE: MIL-8625F TYPE 2 CLASS 2; BLACK OXIDE: QMSI-6.2.2 B.O.
REV D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 6/25/19

Signed: Herbert M. Falt

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com